

Standards

TS EN ISO 2560-A	: E 42 6 1 Ni B 32 H5
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AWS A5.5	: E 7018-G H4

**Chemical Composition of
Weld Metal % (Typical)**

C	Si	Mn	Ni
0.06	0.5	1.0	0.8

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-60°C)	Elongation (L ₀ =5d ₀) (%)
min. 460	530-640	min. 47 J	min. 22

Typical Base Material Grades

- EN 10205: S355J2G3, S355JR, S355JO, S355J2G4, S355K2G3, S355K2G4, ASTM A 572 Gr.50, A709Gr.50, A678Gr.50, A633Gr.D
- API 5L: A, B, X42, X46, X52, X56, X60

Features and Applications

- This is AC/DC basic-coated electrode that has a weld metal recovery of 120% which can be used at all welding positions except for the vertical down position
- Usable with short arc in(-) pole for root pass welding with excellent penetration, especially at vertical-up position
- Weld deposit with high low temperature toughness
- Re-drying: 300-350°C / 2h

Welding Positions

Current Type

D.C.(+) / D.C.(-)
A.C.

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100462	2.50 x 350	3/32 x 14"	60 - 100	2200
3010100465	3.20 x 350	1/8 x 14"	80 - 130	3680
3010100471	4.00 x 350	5/32 x 14"	120- 180	5370

Approvals: TSE, CE, ABS, SEPRO, BV